

Split
FAI
R
Work Order ID 94987 -2

January-02-13 11:44:27 AM

94987

Page 1

Item ID: D4434-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd inboard Bracket Assembly

Start Date: 1/14/13

Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/14/13

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 13-01-03 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4434	B								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D4434-1 as per Dwg								
	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B13-1-23

B13-1-23



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N900040100

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Start Date: 1/14/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/14/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control



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Start Date: 1/14/13 Start Qty: 6.00

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Cust Item ID:

Required Date: 1/14/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

6 76 13-1-24

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.00

Quality Control

6x 13-02-08

180

0.00

180

Small Fab

Memo

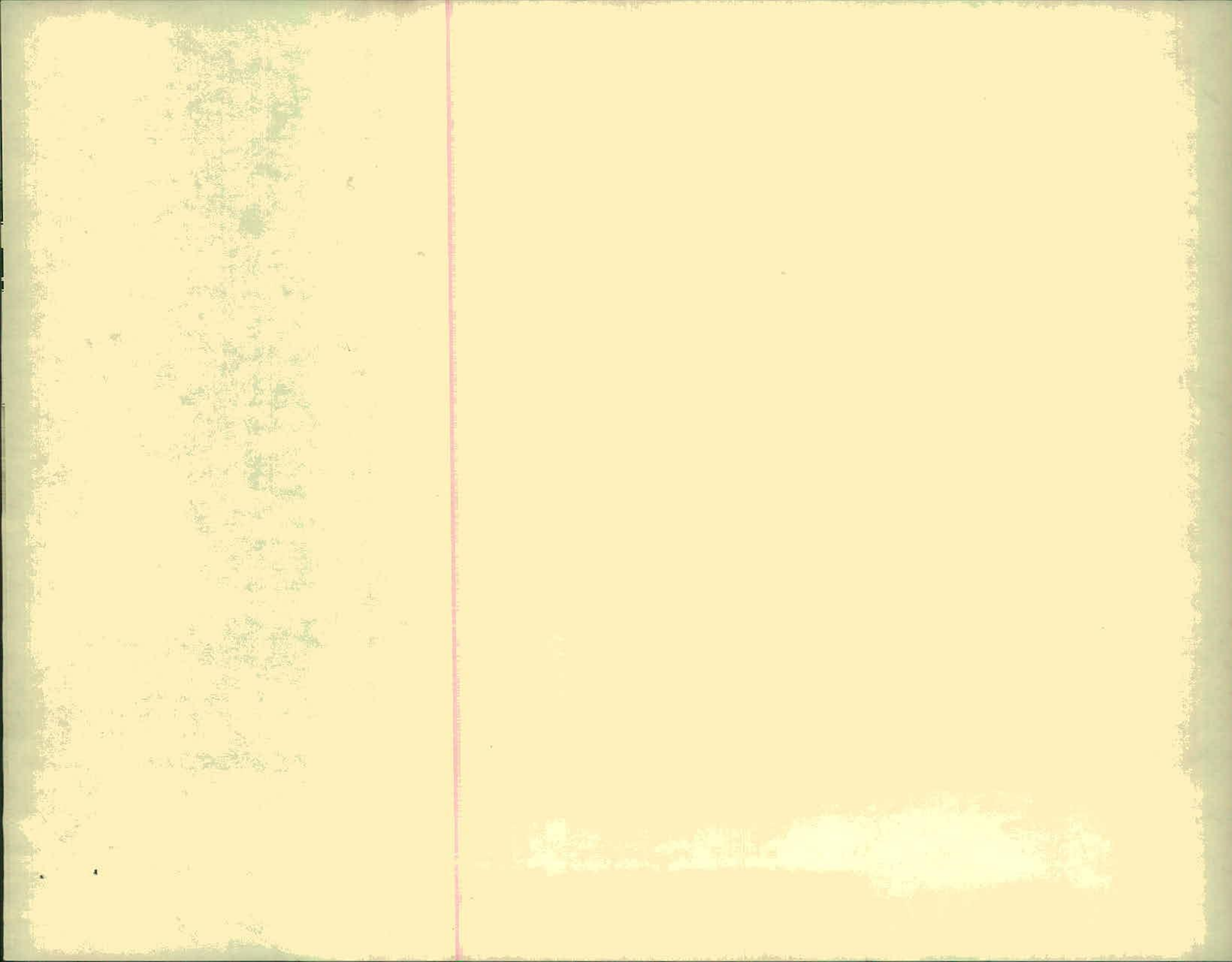
0.00

Small Fab

1-C'sink as per dwg.

2-Assemble as per dwg, do not install grommets and rubber seal.

1 FF 13-02-08



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Item ID: D4434-043

Revision ID:

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Start Date: 1/14/13 Start Qty: 6.00

Required Date: 1/14/13 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

185

185

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

SHS

Memo

0.00

B211

190

190

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3, 9.7) per QSI005 4.3

0.00

M12348

Memo

0.00

*** MASK NUT PLATE HOLES PER DWG ***

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:30
320°
12:00

200

200

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

DA
30

12/02/11

100

200
100

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Page 6

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

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Start Date: 1/14/13

Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/14/13

Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

04706

13/2/14

MF
13-2-10



Picklist Print

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Page 1

Work Order ID: 94987

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 1/14/13

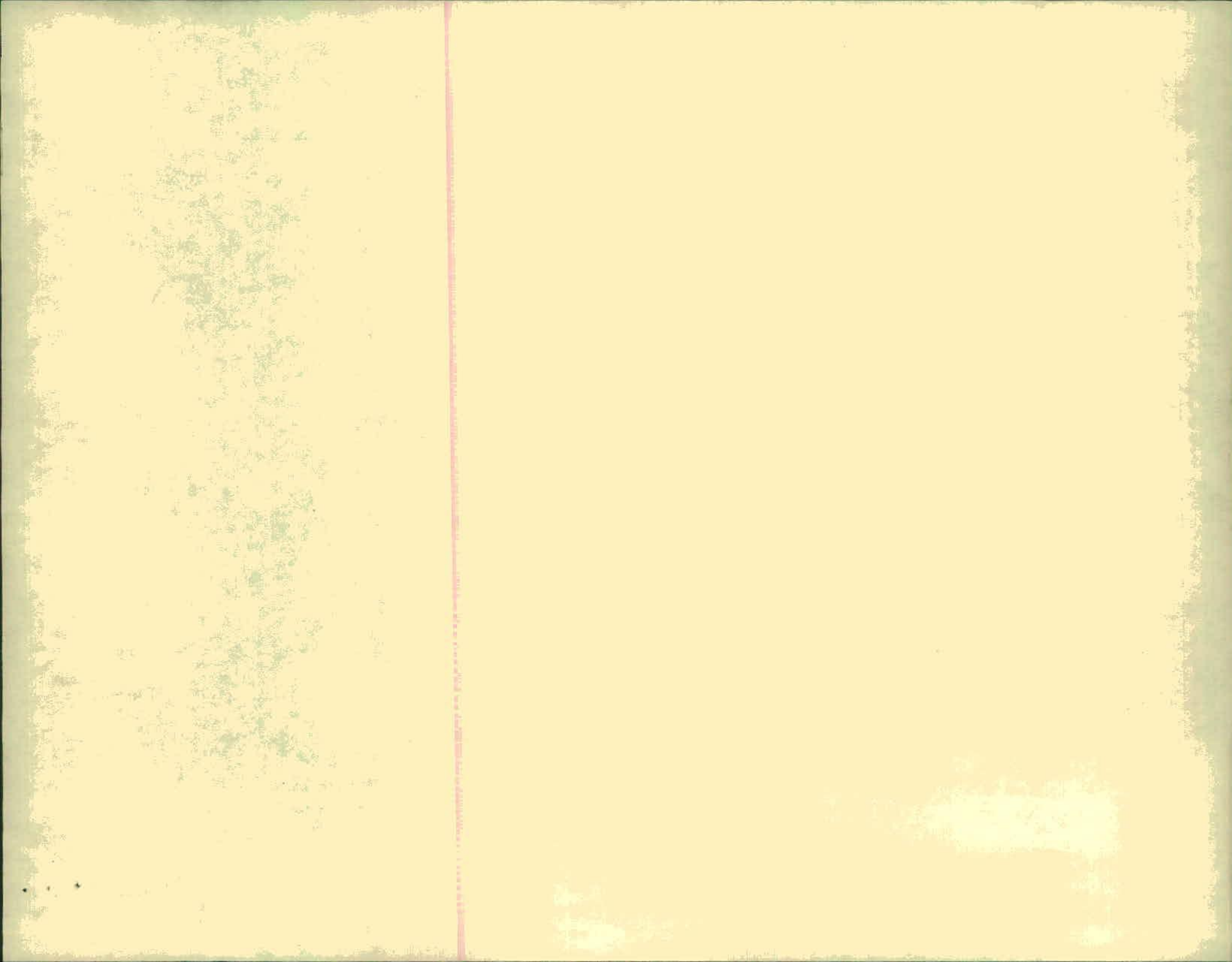
Required Date: 1/14/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PA5
EC verified by:JLM IPP RevC 12.01.24 per REV.A DD verified by:EC
IPP RevD 12.03.05 per REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	861.0726	2.5	15.789473		13-1-23	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		861.0726							
				121099		275.9156							
				123874		585.157							
D4434-9 Bracket		Manufactured	No			180	Each	1.0000	1	6		FF 13-02-08	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1							
				80675		1							
D4435-041 Bracket Assembly		Manufactured	No			180	Each	2.0000	1	6		FF 13-02-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST109		2							
				94059		2							
D4441-1 Rubber Seal		Manufactured	No			202	f	550.3418	0.142	0.852		FF 13-02-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST412		550.3418							
				74760		6.119							
				79385		0.0476							
				80763		78.7672							
				86185		465.408							



Picklist Print

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Work Order ID: 94987

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 1/14/13

Required Date: 1/14/13

Start Qty: 6.00

Required Qty: 6.00

D4441-1 Rubber Seal Manufactured No f 550.3418 1.248 FF 13-02-11

Location	Loc Qty	Loc Code
ST412	550.3418	
74760	6.119	
79385	0.0476	
80763	78.7672	
86185	465.408	

0.200

D4441-1 Rubber Seal Manufactured No f 550.3418 11.25 FF 13-02-11

Location	Loc Qty	Loc Code
ST412	550.3418	
74760	6.119	
79385	0.0476	
80763	78.7672	
86185	465.408	

11.2 1.075

D4440-1 Grommet Manufactured No 202 Each 52.0000 1 6 FF 13-02-11

Location	Loc Qty	Loc Code
GA	51	
80645	1	
91714	50	
ST139F	1	
79372	1	

1

AN525-832R6 Screw Purchased No 180 Each 93.0000 3 18 FF 13-02-11

Location	Loc Qty	Loc Code
GA	4	
120560	4	
ST343	89	
123831	89	

3



Picklist Print

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Work Order ID: 94987

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

MS20426AD3-138

Rivet

130206

Purchased

No

122814

Location

Mezz

1173

13276

MS20426AD3-3

Rivet

Purchased

No

Location

GA

122814

ST316

119109

19099

ST333

121011

123352

MS20470AD4-3

Rivet - Universal Head

Purchased

No

Location

GA

1642

2193

ST335

2193

MS21075L08

ANCHOR NUT

Purchased

No

Location

GA

120560

ST318

103053

121556

123265

Start Date: 1/14/13

Start Qty: 6.00

Required Date: 1/14/13

Required Qty: 6.00

180

Each

18,159.000

12

72

72

13-02-11

Loc Qty

Loc Code

18159

8879

9280

180

Each

7,563.0000

2

12

13-02-11

Loc Qty

Loc Code

493

493

699

282

417

6371

121

6250

12

FF

180

Each

6,491.0000

5

30

13-02-11

Loc Qty

Loc Code

2036

440

1596

4455

4455

30

180

Each

147.0000

7

42

FF 13-02-11

Loc Qty

Loc Code

7

7

140

55

31

54

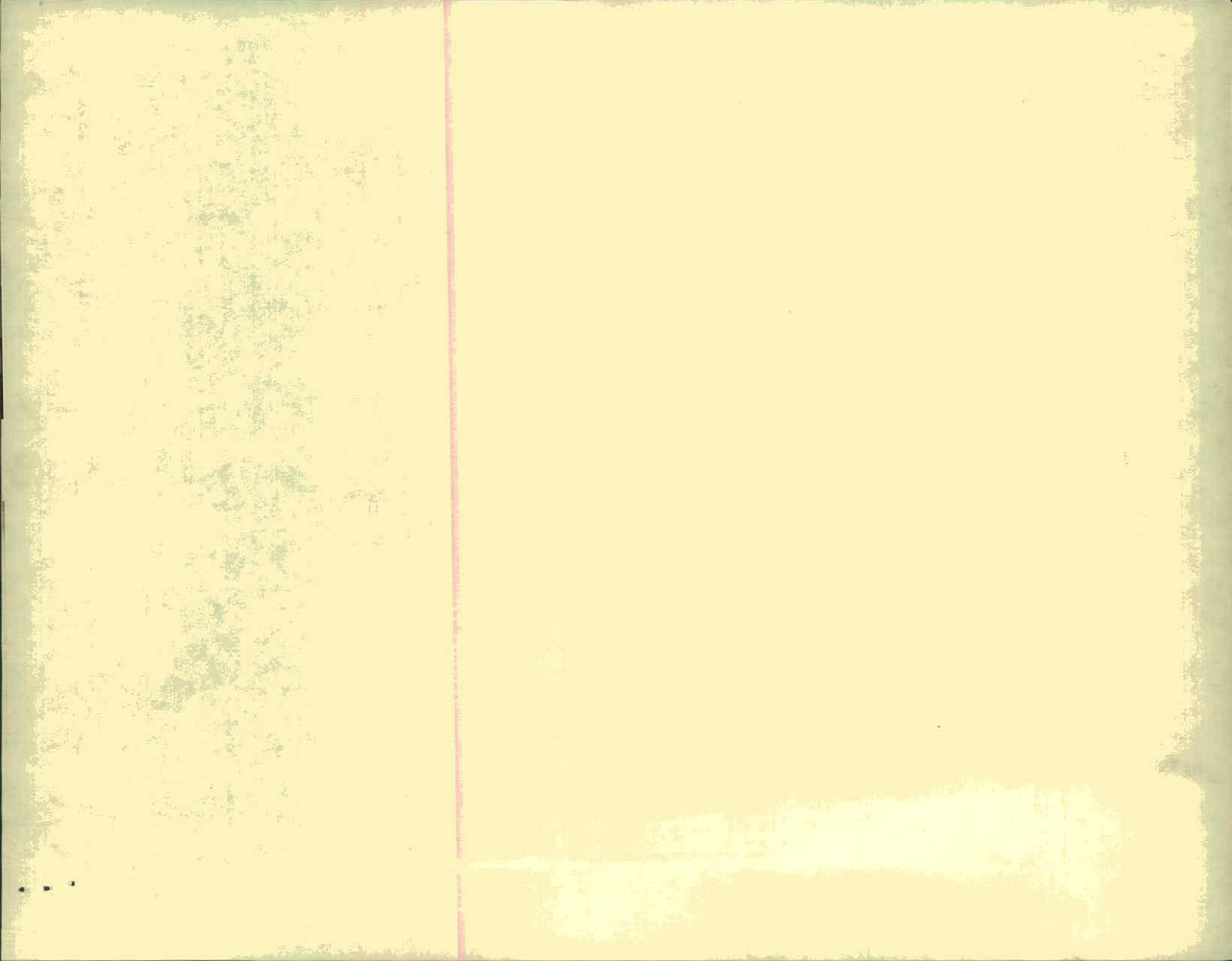
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January-02-13 11:44:26 AM

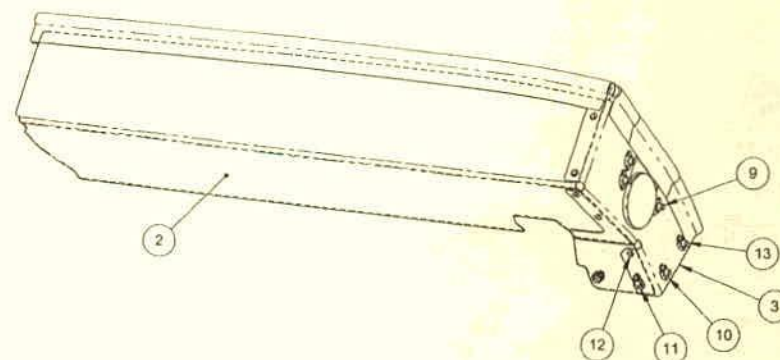
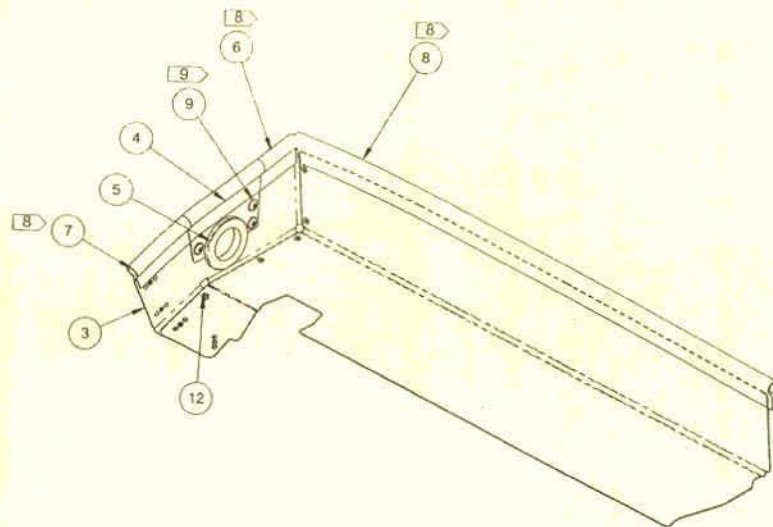
Shop Packet Print

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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4434-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-1	BRACKET
3	1	D4434-9	BRACKET
4	1	D4435-041	BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	1	D4441-1-017	RUBBER SEAL
7	1	D4441-1-025	RUBBER SEAL
8	1	D4441-1-225	RUBBER SEAL
9	3	AN525-832R6	SCREW
10	12	MS20426AD3-2	RIVET
11	2	MS20426AD3-3	RIVET
12	5	MS20470AD4-3	RIVET
13	7	MS21075L08	NUT PLATE
14	A/R	3M 1300/1300L	ADHESIVE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDETEX" (4.3.5.7) PER DART QSI 005 4.3 MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TORQUE SCREW TO 12-15 (in-lb)

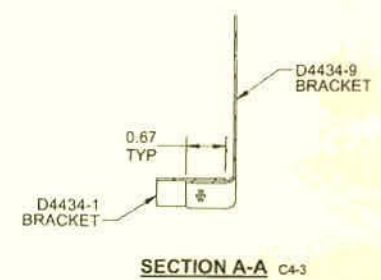
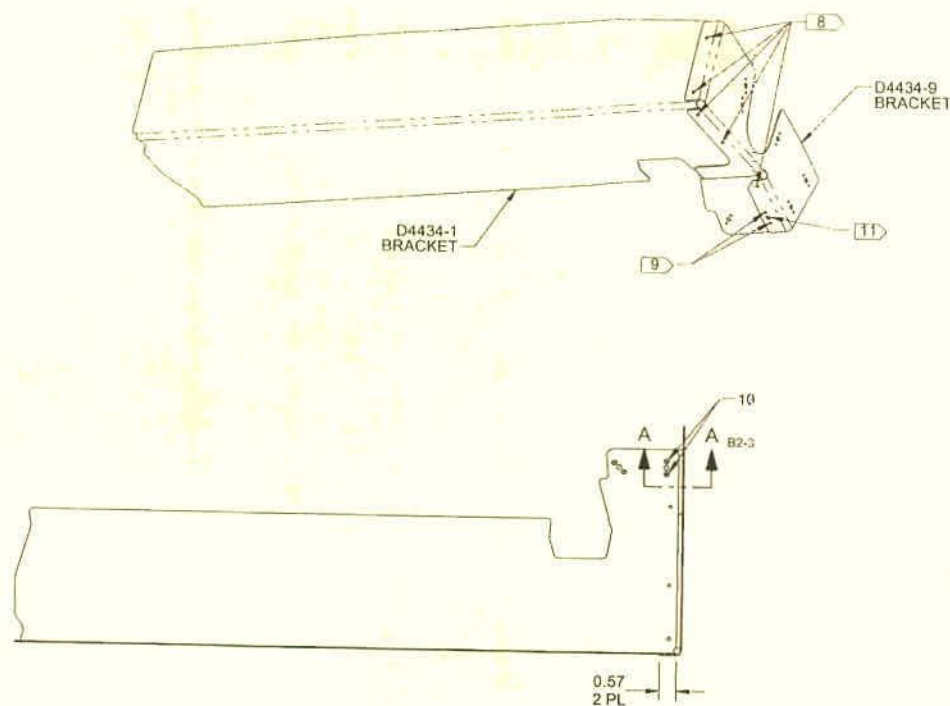
D4434-043 FWD INBOARD BRACKET ASSEMBLY

RELEASED
2012-05-02

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
DRAWN	RF		
CHECKED	RF	DRAWING NO.	SHEET 2 OF 15
MFG. APPR.	RF	D4434	SCALE
APPROVED	RF	TITLE	NTS
DE APPR.	RF	COVER ASSEMBLY	
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94987



D4434-043 FWD INBOARD BRACKET ASSEMBLY
AUXILIARY VIEW

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs
 - 8) TRANSFER $\phi 0.129$ HOLES THRU 5 PLACES FROM D4434-9 TO D4434-1
 - 9) TRANSFER $\phi 0.098$ HOLES THRU 2 PLACES FROM D4434-9 TO D4434-1
 - 10) CSK $\phi 0.179 \times 100^\circ$ ON THIS SIDE 2 PLACES
 - 11) TRANSFER $\phi 0.177$ HOLE THRU FROM D4434-9 TO D4434-1

RELEASED
2012-03-03

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AD	DRAWING NO.	REV. B
MFG. APPR.	EE	D4434	SHEET 3 OF 15
APPROVED	AD	TITLE	SCALE
DE APPR.	#	COVER ASSEMBLY	NTS
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